

Work Order ID 65579

January 20, 2011 9:14:39 AM

Page 1

Item ID: D3755-041

Accept

Revision ID:

Item Name: Seat Cushion

Start Date: 1/20/11 Start Qty: 3.00

Required Date: 2/04/11 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan: CL

Date: 11/01/20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3753

Rev D

D3755

Rev C

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13330

Manufacture D3753-1 cushion as per dwg Dwg D3753

Upholster as per Dwg D3755

Supplier: Aerotex

Material release note is required

CL 11/01/20 (3)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00






Packaging

CL 11/20/20 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3755-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>65579</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.03.16	100	FOAM WAS NOT CORRECT, WRONG DENSITY	 11.03.16 (P5)042	REPLACE WITH CORRECT DENSITY FOAM B/N <u>13330</u>	 11/03/22	 11/03/23	 11.03.16 (P5)042	 11/03/23

NOTE: Date & initial all entries

Work Order ID 65579

January 20, 2011 9:14:39 AM



Page 2

Item ID: D3755-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Cushion

Start Date: 1/20/11 Start Qty: 3.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8u(03/23)

(23)

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/3/23

(30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23

CL 11/03/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 20, 2011 9:14:39 AM

Page 1

Work Order ID: 65579

Parent Item: D3755-041

Parent Item Name: Seat Cushion




Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: A 08.11.17 New issue EC verified by:DD IPP Rev:B
10.04.13 as per ECN10-539 Verified by:EC IPP Rev:C 10.05.03
remove velcro per comment (W/O 58260) DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3755-041P  Seat Cushion		Purchased	No			110	Each	0.0000	1	3		1/24/11	(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

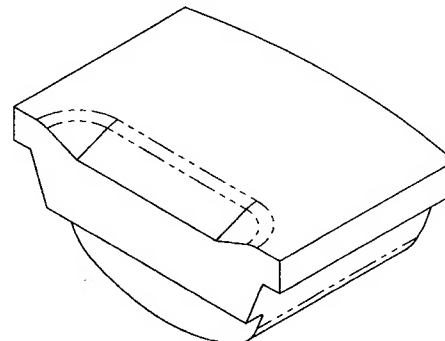
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -1	PART NUMBER	DESCRIPTION
1	X		D3755-041	CUSHION
2	1	X	D3755-1	COVER
3	1		D3753-1	SEAT FOAM
4		2	LOOP STRIP, 2"	3M SJ3418FR, 2" WIDE BEIGE OR D3800-1-200-100
5	A/R		LOOP STRIP, 1"	3M SJ3418FR, 1" WIDE BEIGE OR D3800-1-100-400
6		A/R	HOOK STRIP, 1"	APLIX 800, A800R0025H958-1, 1" WIDE BEIGE OR D3800-3-100-400
7		A/R	FABRIC	JACKSON GREY MIX
8		A/R	THREAD	BONDED POLYESTER, 14.2 lb BREAK STRENGTH, GREY COLOR
9	A/R		ADHESIVE	3M 1300 / 1300L RUBBER AND GASKET ADHESIVE OR SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
10		A/R	ZIPPER	PACANNA BRASS AUTOLOCK ZIPPER #5



D3755-041 CUSHION

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3755-041" USING LABEL
- 7) WEIGHT: 3.3 lbs APPROX
- 8) SEW D3755-1 COVER TO FIT D3753-1 FOAM
- 9) STITCH ZIPPER ALONG EDGE OF SEAM TO CLOSE COVER
- 10) TO PULL FABRIC AGAINST FOAM IN CONCAVE AREAS, STITCH HOOK STRIP (1") TO INSIDE OF COVER AS REQ'D.
BOND LOOP STRIP (1") TO FOAM.
- 11) STITCHING: 4-6 STITCHES PER INCH, USE MIN 1/2" BACKSTITCH, NO LOOSE THREADS
- 12) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT9419
- 13) ANY REQUIRED BONDING SHOULD BE DONE WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
OR 3M 1300/1300L RUBBER AND GASKET ADHESIVE

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CL 11/01/20

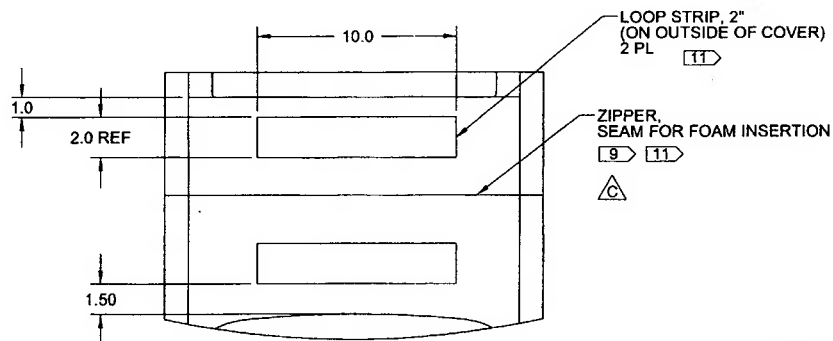
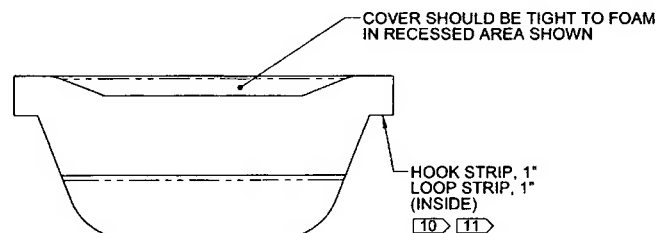
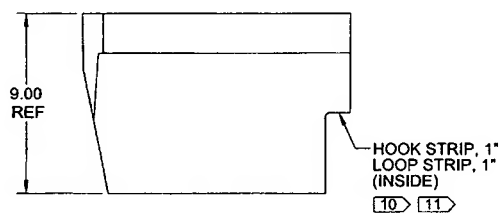
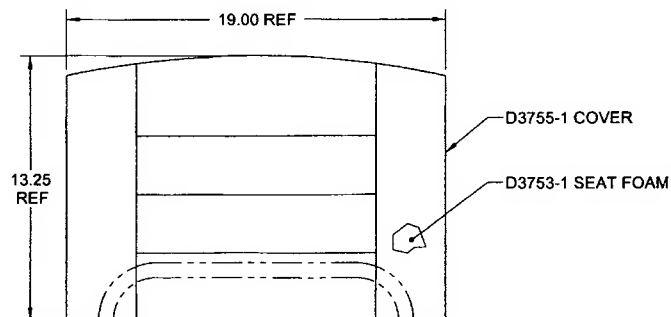
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2010-03-23

C	UPDATE TO VIEWS/NOTES DUE TO D3753 BEING RESHAPED & NEW MFR. FABRIC, HOOK, LOOP, ADHESIVE CHG (D5-1), ADD ZIPPER (D5-1, B4-2). REF PAR 09-030.	CP	10.02.02
B	COVER NOW CLOSED WITH SINGLE SEAM (ZN A8-1, B3-2). D3800-1-100-300 WAS D3800-1-100-800 (D8-1), D3800-3- 100-300 WAS D3800-3-100-800 (D8-1), ORIENTATION OF D3800-1-200-060 CHANGED (B3-2), ADD ITEM NUMBERS TO PART LIST (D8-1)	CP	08.10.21
A	NEW ISSUE	CP	08.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	10.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3755** REV. C
TITLE **CUSHION** SCALE NTS
SHEET 1 OF 2

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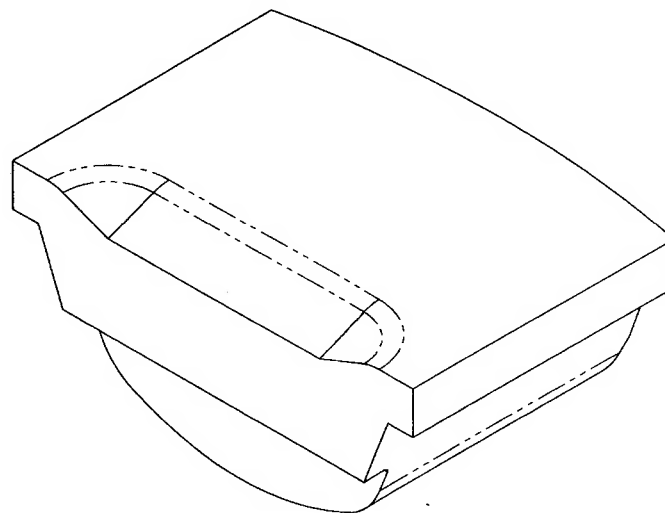


D3755-041 SEAT CUSHION

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NO. 6557

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2010-03-23

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3755	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION	NTS
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D3753-1 SEAT FOAM

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WORK ORDER
NO. 65579

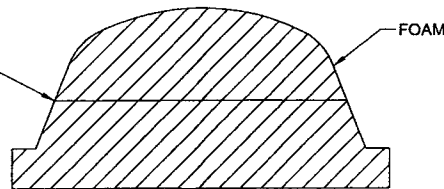
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2010-03-23
mp

NOTES:

- 1) MATERIAL:
FOAM = FOAMEX H270-40S1 FOAM
OR
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING GRADE 40-50 (COLOR: LIGHT YELLOW)
SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 503330-99
ADHESIVE = BOND FOAM LAYERS (IF REQUIRED) WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
OR 3M 1300/1300L RUBBER AND GASKET ADHESIVE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3753-1" USING PERMANENT MARKER
- 7) WEIGHT: 3.3 lbs APPROX
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT9027

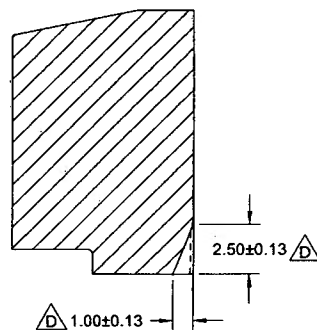
D	RE-SHAPED TO IMPROVE COMFORT PER PAR 09-030. ADD FOAMEX & 3M 1300 MAT'L (ZN A8-1)	CP	10.02.02
C	CHG SHAPE TO MATCH CHESTNUT SAMPLE: 5.69 WAS 5.85 (B8-2), 4.00 WAS 4.25 (B3-2), 1.25 WAS 1.00 (B3-2)	CP	08.10.08
B	FOAM SHORTER TO AVOID CYCLIC, 12.25 WAS 16.75 (C7- 2), 5.85 WAS 6.88 (B8-2), FRONT PROFILE CHANGED (B3-2)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.02		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3753 SEAT FOAM <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			
			REV. D SHEET 1 OF 2 SCALE NTS

BOND FOAM LAYERS (IF PRESENT)
WITH SILAPRENE DC12906
OR 3M 1300/1300L ADHESIVE

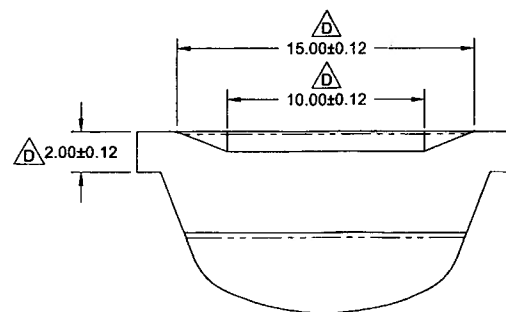
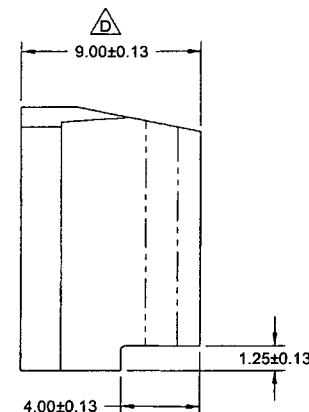
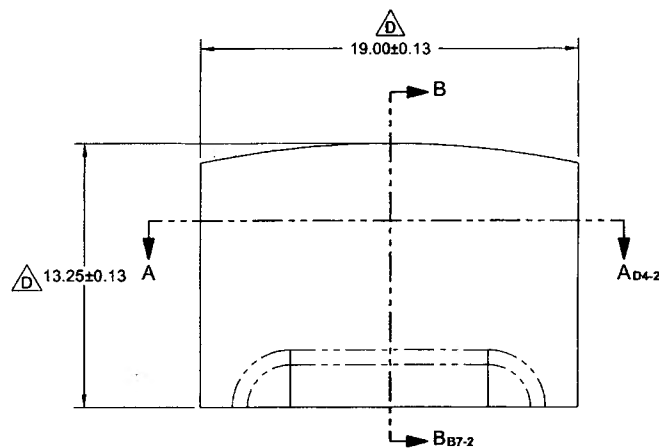


SECTION A-A C4-2

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WORK ORDER
NO. 65579



SECTION B-B B5-2



D3753-1 SEAT FOAM

RELEASED
2010-03-23
MP

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3753	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SEAT FOAM	NTS
DATE	10.02.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13330

Purchase Order Date 1/20/11

PO Print Date 2/15/11

Page Number 1 of 1

Order From :

VC-AER003

AEROTEX INTERIORS INC.
#24-2333 18TH AVENUE N. E.
CALGARY, AB T2E 8T6
CA

Contact Name
Vendor Phone 403 295 8770
Vendor Fax 403 313 0793
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A JK7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3755-041P	Seat Cushion	2/04/11 Yes	3.00 Each	FedEx PI collect	\$425.0000	\$1,275.00
		Special Inst:	AS PER DWG D3755 REV. C B65579				
2	D3756-041P	Cushion	2/04/11 Yes	3.00 Each	FedEx PI collect	\$425.0000	\$1,275.00
		Special Inst:	AS PER DWG D3756 REV. C B65580				
PO Total:							\$2,550.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 2/15/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date	Packing Slip#
15/02/2011	7875

Ship To	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FED EX	1517-9324-0

Invoice To
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

Ship Date	P.O. No.
15/02/2011	13330

Aircraft	Description	Part Number	Qty
DART DART	BACK CUSHION SEAT CUSHION GST On Sales	D3756-041 D3755-041	3 3

Thank you for your business.

www.aerotexinteriors.com

GST/HST No. 139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:

13330

Our Work Order:

7875

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

PILOT GREY MIX FABRIC

1" VELCRO LOOP - BEIGE - D3800-1-100-700

1" VELCRO HOOK - BEIGE - D3800-3-100-700

2" VELCRO LOOP - BEIGE - D3800-1-200-600

FOAM - H270-40S1

FOAM - H250-35S1

THREAD - BONDED POLYESTER, 14.2 lb BS Grey

ADHESIVE - 3M 3100 RUBBER ADHESIVE

ZIPPER - PACANNA BRASS AUTOLOCK ZIPPER #5

FOAM - FOAMEX H270-40S1

FOAM - FOAMEX H270-35S1

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH DWG NO. D3755 REV. C and DWG NO. D3756 REV. C

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

